

What Is Claimed Is:

Sub 47 1. A hollow rack shaft for a steering system, having:
two rack teeth groups respectively formed by plastic working
and located longitudinally apart from each other.

2. A hollow rack shaft according to Claim 1, wherein:
said rack teeth groups are out of phase by an angle around
the axis of said shaft.

3. A hollow rack shaft formed of one plate workpiece for a
steering system, wherein:

two rack teeth groups respectively formed by plastic working
and located longitudinally apart from each other.

4. A hollow rack shaft according to Claim 3, wherein:
said rack teeth groups are out of phase by an angle around
the axis of said shaft.

5. A hollow rack shaft according to Claim 4, wherein:
said rack teeth groups are sequentially formed by die
forming.

6. A hollow rack shaft according to Claim 4, wherein:
said rack teeth groups are simultaneously formed by die
forming.

7. A method of manufacturing a hollow rack shaft for a
steering system having two rack teeth groups, said groups being
located longitudinally apart from each other and out of phase by
an angle around the axis of said shaft, wherein:

said shaft is formed of one plate workpiece having two areas;
and

the center lines in the longitudinal direction at said areas
are offset corresponding to phase difference between said rack
teeth groups.

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